

# Work Order ID 68183

Thursday, April 07, 2011 4:05:28 PM



Page 1

Item ID: D412-711-021

Accept



Setup Start



Revision ID:

Stop



Item Name: Vertical Reference Door Modification

Start Date: 4/7/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

MF

Date:

11-04-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D412-711

G

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefiles and create labels per PPP D412-711-021 CHG001

11-04-11 13 11

120

0.00



Pick Kit

Purchasing

Packaging

Memo

0.00

Packaging

11-04-11 13 11

130

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

11-04-11 13 11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 68183**

Thursday, April 07, 2011 4:05:28 PM



Page 2

Item ID: D412-711-021

Accept



Setup Start



Revision ID:

Stop



Item Name: Vertical Reference Door Modification

Start Date: 4/7/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-711-021

Location: \_\_\_\_\_

PPP rev: \_\_\_\_\_

4/14/13 (1)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

4/14/13

MF

11-04-13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 07, 2011 4:05:23 PM

Page 1

Work Order ID: 68183

Parent Item: D412-711-021

Parent Item Name: Vertical Reference Door Modification

Start Date: 4/7/2011

Required Date: 4/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.04.07 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-761-043 Modified Latch Mechanism, LH		Manufactured	No			120	Each	0.0000	1	68193			
D412-711-101 Replacement Bubble Window		Manufactured	No			120	Each	2.0000	1	67081			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG091				2					
					67081			2					
D3802-1-120 Window Seal		Manufactured	No			120	Each	0.0000	1	68443			
D4165-1 Doubler		Manufactured	No			120	Each	2.0000	1				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST				2					
					68120			2		68120			
D4165-3 Inner Door Panel		Manufactured	No			120	Each	2.0000	1				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST				2					
					68121			2		68121			

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Thursday, April 07, 2011 4:05:23 PM

Page 2

Work Order ID: 68183

Parent Item: D412-711-021

Parent Item Name: Vertical Reference Door Modification

Start Date: 4/7/2011

Required Date: 4/12/2011

Start Qty: 1.00

Required Qty: 1.00

D4165-5 Manufactured No 120 Each 3.0000

Aft Rib

Location

Loc Qty

Loc Code

ST

3

68125

3

D4165-7 Manufactured No 120 Each 0.0000

Fwd Rib

D4165-9 Manufactured No 120 Each 3.0000

Angle

Location

Loc Qty

Loc Code

ST

3

68123

3

D4165-11 Manufactured No 120 Each 0.0000

Door Cover Panel

D4207-1 Manufactured No 120 Each 0.0000

Window Retainer

D4207-3 Manufactured No 120 Each 0.0000

Instrument Window

D4269-1 Manufactured No 120 Each 0.0000

Angle

D4269-3 Manufactured No 120 Each 0.0000

Angle

Thursday, April 07, 2011 4:05:24 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries



# Picklist Print

Thursday, April 07, 2011 4:05:24 PM

Page 3

Work Order ID: 68183

Parent Item: D412-711-021












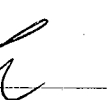






Parent Item Name: Vertical Reference Door Modification

Start Date: 4/7/2011

Required Date: 4/12/2011

Start Qty: 1.00

Required Qty: 1.00

 D4269-5 Angle	Manufactured	No	120	Each	0.0000	 1	68129	
 D4269-7 Angle	Manufactured	No	120	Each	0.0000	 1	68130	
 D4324-041 Armrest Assembly	Manufactured	No	120	Each	0.0000	 1	68146	
 D4324-043 Arm Support Assembly	Manufactured	No	120	Each	0.0000	 1	68147	
 D4327-1 Angle	Manufactured	No	120	Each	0.0000	 1	68152	
 D4327-3 Angle	Manufactured	No	120	Each	2.0000	 1	68153	

## Location

## Loc Qty

## Loc Code

ST

2

68153

2

Manufactured No

120

Each

0.0000



2

68141



Placard

Thursday, April 07, 2011 4:05:24 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Thursday, April 07, 2011 4:05:24 PM

Page 4

Work Order ID: 68183

Parent Item: D412-711-021

Parent Item Name: Vertical Reference Door Modification

Start Date: 4/7/2011

Required Date: 4/12/2011

Start Qty: 1.00

Required Qty: 1.00



Purchased No 120 Each 332.0000

22

22



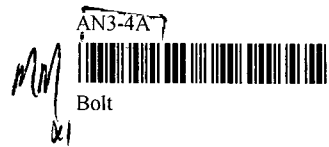
4/5/11/04/13

Location Loc Qty Loc Code

ST350 332

116419 32

116924 300



Purchased No 120 Each 100.0000

20

20



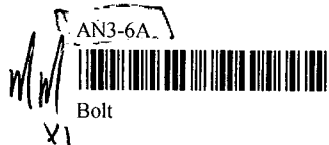
4/5/11/04/13

Location Loc Qty Loc Code

ST350 100

117317 100

M114374 (200)



Purchased No 120 Each 212.0000

26

26



4/5/11/04/13

Location Loc Qty Loc Code

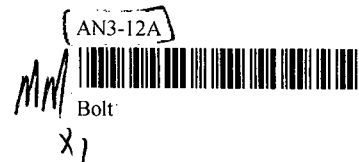
ST351 212

114941 62

116191 50

116704 100

26



Purchased No 120 Each 121.0000

1

1



4/5/11/04/13

Location Loc Qty Loc Code

ST351 121

114536 21

116786 100

1

Thursday, April 07, 2011 4:05:24 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, April 07, 2011 4:05:24 PM

Work Order ID: 68183

Parent Item: D412-711-021

Parent Item Name: Vertical Reference Door Modification

Start Date: 4/7/2011

Required Date: 4/12/2011

Start Qty: 1.00

Required Qty: 1.00

(NAS1149F0332P)

Purchased

No

120

Each

414.0000

92

92

WASHER

Location

Loc Qty

Loc Code

ST275

414

17317

400

18057

14

120

Each

100.0000

34

34

(CR3242-4-2)

Purchased

No

Rivet

Location

Loc Qty

Loc Code

ST312

100

116583

100

120

Each

3,389.000

135

135

MS20426AD3-3

Purchased

No

Rivet

Location

Loc Qty

Loc Code

ST316

3389

19099

3389

120

Each

4,537.000

140

140

MS20426AD4-3

Purchased

No

Rivet

Location

Loc Qty

Loc Code

ST317

4537

113064

4537

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, April 07, 2011 4:05:24 PM

Work Order ID: 68183

Parent Item: D412-711-021

Parent Item Name: Vertical Reference Door Modification

Start Date: 4/7/2011

Required Date: 4/12/2011

Start Qty: 1.00

Required Qty: 1.00

MS20470AD3:3

Purchased

No

120

Each

9,664.000



Rivet, Universal Head

## Location

## Loc Qty

## Loc Code

ST319

9664

1065

1435

16941

8229

120

Each

6,187.000

MS20470AD4:3

Purchased

No



Rivet - Universal Head

## Location

## Loc Qty

## Loc Code

MEZZ

6187

1642

1553

2193

4634

120

Each

2,045.000

MS21042L3

Purchased

No



Nut

## Location

## Loc Qty

## Loc Code

ST300

2045

116391

445

116540

800

116549

800

120

Each

19.0000

MS21059L3

Purchased

No



Nut Plate

## Location

## Loc Qty

## Loc Code

ST302

19

116706

19

25  
EP 11/04/13

25  
90  
EP 11/04/13

24  
24  
EP 11/04/13

4  
4  
EP 11/04/13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Thursday, April 07, 2011 4:05:25 PM

Work Order ID: 68183

Parent Item: D412-711-021

Parent Item Name: Vertical Reference Door Modification

Start Date: 4/7/2011

Required Date: 4/12/2011

Start Qty: 1.00

Required Qty: 1.00

MS21069L3

Purchased No

120

Each

100.0000

34

34

ANCHOR NUT

Location

Loc Qty

Loc Code

ST302

100

103447

30

112314

20

115708

50

15  
19

MS21069L08

Purchased No

120

Each

76.0000

8

8

ANCHOR NUT

Location

Loc Qty

Loc Code

MEZZ

76

102587

76

8

MS21071L3

Purchased No

120

Each

97.0000

3

3

ANCHOR NUT

Location

Loc Qty

Loc Code

ST302

97

102587

47

114348

50

3

MS21071L08

Purchased No

120

Each

186.0000

1

ANCHOR NUT

Location

Loc Qty

Loc Code

MEZZ

186

102587

86

103447

100

1

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

REFERENCE ONLY

11-04-13

QTY -011	QTY -013	QTY -015	QTY -017	QTY -019	QTY -021	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X								D412-711-011	VERTICAL REFERENCE DOOR INSTALLATION, 212/412
	X							D205-711-013	VERTICAL REFERENCE DOOR INSTALLATION, 205/210
		X						D204-711-015	VERTICAL REFERENCE DOOR INSTALLATION, 204
			X					D214-711-017	VERTICAL REFERENCE DOOR INSTALLATION, 214
				X				D212-711-019	VERTICAL REFERENCE DOOR EAGLE SINGLE
1	1	1	1	1	X			D412-711-021	VERTICAL REFERENCE DOOR KIT
						X		D412-711-041	VERTICAL REFERENCE DOOR ASSEMBLY
							X	D412-711-043	SNAP VENT KIT
						1		D412-761-043	MODIFIED LATCH MECHANISM KIT, LH (REPLACES EA20469-23/-24/-25)
					1			D412-711-101	REPLACEMENT WINDOW (REPLACES EAGLE P/N EB212-100L / EA20469-3)
					1			D3802-1-120	RUBBER STRIP
							2	D3932-1	SNAP VENT
					1			D4165-1	DOUBLER
					1			D4165-3	DOOR INNER SKIN (REPLACES EA20469-18)
					1			* D4165-5	AFT RIB (REPLACES EA20469-34)
					1			** D4165-7	FWD RIB (REPLACES EA20469-31)
					1			D4165-9	ANGLE (REPLACES EA20469-17)
					1			D4165-11	DOOR COVER PANEL (REPLACES EA20469-21)
					1			D4207-1	WINDOW RETAINER (REPLACES EA20469-14)
					1			D4207-3	WINDOW (REPLACES EA20469-13)
					1			D4269-1	ANGLE (REPLACES EA20469-33)
					1			D4269-3	ANGLE (REPLACES EA20469-30)
					1			** D4269-5	ANGLE (REPLACES EA20469-29)
					1			* D4269-7	ANGLE (REPLACES EA20469-32)
					1			** D4324-041	ARM REST ASSEMBLY
					1			*** D4324-043	ARM SUPPORT ASSEMBLY
					1			D4327-1	ANGLE (REPLACES EA20469-11)
					1			D4327-3	ANGLE (REPLACES EA20469-07)
					2	2		D4385-1	PLACARD

- \* PART OF EA20469-10 REAR RIB ASSEMBLY
- \*\* PART OF EA20469-12 FWD RIB ASSEMBLY
- \*\*\* PART OF EA20469-16 ARM REST ASSEMBLY

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.	N/A	D412-711	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		VERTICAL REFERENCE DOOR NTS	
DATE	11.03.31	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

# REFERENCE ONLY

M/M H-04-13

QTY -011	QTY -013	QTY -015	QTY -017	QTY -019	QTY -021	QTY -041	PART NUMBER	DESCRIPTION
					22	22	AN3-3A	BOLT
					20	20	AN3-4A	BOLT
					26	26	AN3-6A	BOLT
					1	1	AN3-12A	BOLT
					92	92	NAS1149F0332P	WASHER (OR AN960-10L)
					34	34	CR3242-4-2	RIVET
					135	135	MS20426AD3-3	RIVET
					140	140	MS20426AD4-3	RIVET
					25	25	MS20470AD3-3	RIVET
					90	90	MS20470AD4-3	RIVET
					24	24	MS21042L3	NUT
					4	4	MS21059L3	NUT-PLATE
					34	34	MS21069L3	NUT-PLATE
					8	8	MS21069L08	NUT-PLATE
					3	3	MS21071L3	NUT-PLATE
					1	1	MS21071L08	NUT-PLATE
A <sub>1</sub>	A <sub>1</sub>	A <sub>1</sub>	A <sub>1</sub>	A <sub>1</sub>		1	204-030-853-119	LH COPILOT DOOR
1							D412-711-111	WIRING HARNESS, 212/412
B <sub>1</sub>							D4268-043	INSTRUMENT PANEL, 212/412 (REPLACES EA20469-15-412)
	1						D205-711-113	WIRING HARNESS, 205
	B <sub>1</sub>						D4268-041	INSTRUMENT PANEL, 205 (REPLACES EA20469-15-205)
		1					D204-711-115	WIRING HARNESS, 204
		B <sub>1</sub>					EA20469-15-204	INSTRUMENT PANEL, 204
			1				D214-711-117	WIRING HARNESS, 214
			B <sub>1</sub>				EA20469-15-214	INSTRUMENT PANEL, 214
				1			D212-711-119	WIRING HARNESS, EAGLE SINGLE
				B <sub>1</sub>			D4268-047	INSTRUMENT PANEL, EAGLE SINGLE

(A) CUSTOMER SUPPLIED

(B) INSTRUMENT PANEL INCLUDED WITH HARNESS ABOVE

## NOTES

### 1) WIRING HARNESSES:

For Bell 204/205/210/214 Wiring Harnesses, use drawing D2046904.  
For Bell 212 Wiring Harnesses, use drawing D2046903.  
For Bell 412 Wiring Harnesses, use drawing D412-711-901.  
For Bell 212 modified per SH07-28/SR02831NY use D212-761-224  
or D212-761-225 depending on aircraft s/n.

Wiring Harnesses will vary  
depending on aircraft s/n.

### 2) D412-711-101 REPLACEMENT WINDOW:

To increase downward viewing clarity, it is acceptable to cut a small section from the replacement window on its downward side per Figure 1 of this document. The cutout can be a maximum of 9.00" wide x 17.00" long (229mm x 432mm), measured along the profile of the replacement window. The corners of the cutout must have a minimum radius of 2" (50mm). The cutout should be located at least 1.0" (25mm) from the flange. The actual shape of the cutout can vary as desired, as long as the overall dimensions are within the specified limits. See Figure 1 for reference.

### 3) D412-711-043 SNAP VENT KIT:

It is acceptable to install a total of up to 2X D3932-1 Snap Vents (available from Dart) onto the D412-711-101 Replacement Window to provide ventilation into the cabin. Refer to Figure 1 for acceptable locations and size of cutouts.

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.	N/A	D412-711	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		VERTICAL REFERENCE DOOR NTS	
DATE	11.03.31	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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